

Date: Tuesday, 10/23/2007 3:11:05 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : SUPPORT BRACKET
Job Number : 35328	
Estimate Number : 10260	
P.O. Number : <i>N/A</i>	Part Number : D23623
This Issue : 10/23/2007 S.O. No. : <i>N/A</i>	Drawing Number : D2362 REV E1
Prsht Rev. : NC	Project Number : N/A
First Issue : <i>N/A</i> Type : MACHINED PARTS	Drawing Revision : E1
Previous Run : 34292	Material : <i>N/A</i>
Written By : <i>[Signature]</i>	Due Date : 11/25/2007 Qty: <i>15</i> Um: Each
Checked & Approved By : <i>[Signature]</i>	
Comment : Est: G 00.05.18 Added inspection level 8 EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	D2265	Step Support Casting
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

Step Support

Pick:

Qty Part Number Description Batch

1 D2265 Step Support

*29807**7/07-11-1 (15)*

2.0	HAAS1	HAAS CNC VERTICAL MACHINING #1
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Comment: Machine per folio D2362-3

J.L 07/11/28

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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Comment: Inspect Level 2

J.L 07/11/28

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

2F 07/12/02

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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Comment: SMALL & MEDIUM FAB RESOURCE 1

Deburr

SB 07/12/04 (15)

6.0	POWDER COATING	POWDER COATING
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Comment: POWDER COATING

Powder Coat Gloss White (Ref 4.3.5.1) as per Dart QSI 005 4.3

FX 07/12/04 (15)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☐ No ☒ DQA: ☒ Date: 21/12/11
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 10/23/2007 3:11:05 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SUPPORT BRACKET

Job Number: 35328

Part Number: D23623

Job Number:



Seq. #:

Machine Or Operation:

Description :

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



(SX)

Comment: INSPECT POWDER COAT

M-L

07/12/04

8.0

D23971

Rubber Cushion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

Rubber Cushion

Pick:

Qty Part number

Description

Batch

1

D2397-1

Rubber

B30971

X 13mx,

B 36/17

x 2mx

mf

9.0

D23973

Rubber Cushion



Comment: Qty.: 1.0000 Each(s)/Unit Total : 12.0000 Each(s)

Rubber Cushion

Pick:

Qty Part number

Description

Batch

1

D2397-3

Rubber

B30972

x 13mx,

B 26/18

x 2mx

mf 07-12-07

10.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Bond rubber D2397-1 followed by D2397-3 using contact cement
as per Dwg D2362

Batch

M102005

mf 07-12-10

(15)

11.0

QC5

INSPECT WORK TO CURRENT STEP



counts

Comment: INSPECT WORK TO CURRENT STEP

07/12/10 (15)

12.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST478

W

07/12/10

(15)

13.0

QC21

FINAL INSPECTION/W/O RELEASE



(15)

Comment: FINAL INSPECTION/W/O RELEASE

07/12/11

Job Completion



W 07/12/11

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	35328
Description: Step Support Bracket		Part Number:	D2362-3
Inspection Dwg: D2362 Rev: E1		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.257	+0.005 -0.000	.259	✓			
3.074	+/-0.010	3.074	✓			
0.34	+/-0.030	.336	✓			
0.77	+/-0.030	.780	✓			
1.500	+/-0.010	1.499	✓			
1.000	+/-0.010	1.010	✓			
0.80	+/-0.030	.770	✓			
1.200	+/-0.010	1.210	✓			
1.28	+/-0.030	1.263	✓			
1.000	+/-0.010	.990	✓			
0.75	+/-0.030	.760	✓			
1.88	+/-0.030	1.877	✓			

Measured by:	J.L.	Audited by:	S.F.	Prototype Approval:	N/A
Date:	07/11/28	Date:	07/12/02	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	03.10.07	New Issue	KJ/RF	TH



RELEASED
98.12.14 KE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. E
BW	CP		
CHECKED KE	APPROVED CP	DRAWING NO. D2362	SHEET 1 OF 3
DATE 98.12.04		TITLE STEP SUPPORT BRACKET	SCALE 1:2
A	95.02.15	NEW ISSUE	
B	95.03.22	CHANGED RUBBER TO D2397	
C	96.01.22	ADD D2362-5	
D	97.05.21	ADD D2362-7	
E	98.12.04	REDRAWN, ADD 2397-5	

UNDER REVIEW

01.03.15 CP

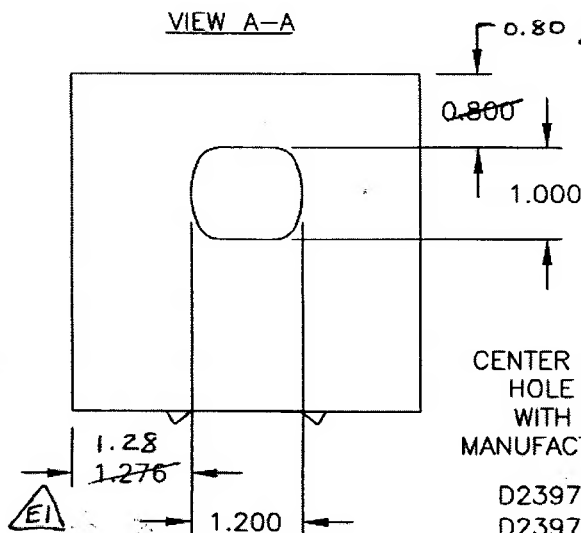
DESIGN OK, BUT CHECK WITH
3/3 BEFORE MANUFACTURE
OK 01/11/09

0.257 X 0.75 SLOT
REMOVE TIPS
FROM CASTING
MAX 0.080

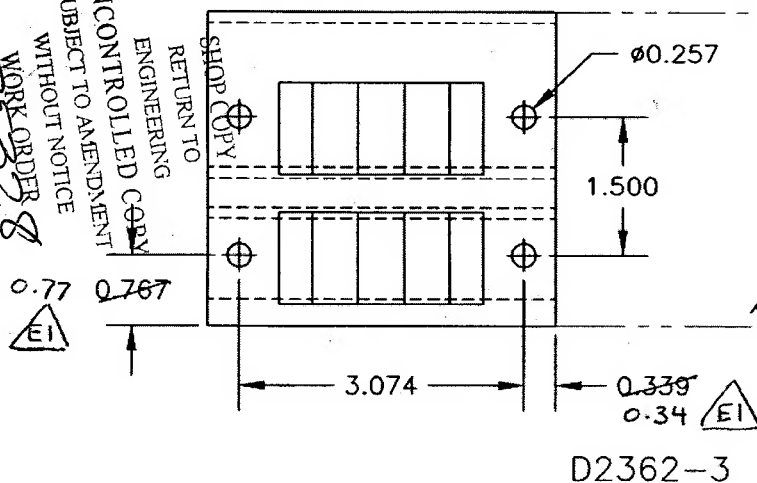
CENTER D2397-1/-3 RUBBER
HOLE WITH SLOT AND BOND
WITH CONTACT CEMENT PER
MANUFACTURER'S SPECIFICATION

D2397-1 RUBBER CUSHION (1)
D2397-3 RUBBER CUSHION (1)

VIEW A-A



RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
35328



NOTES:

MAKE FROM D2265

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3 BEFORE BONDING
RUBBER IN PLACE

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

DART

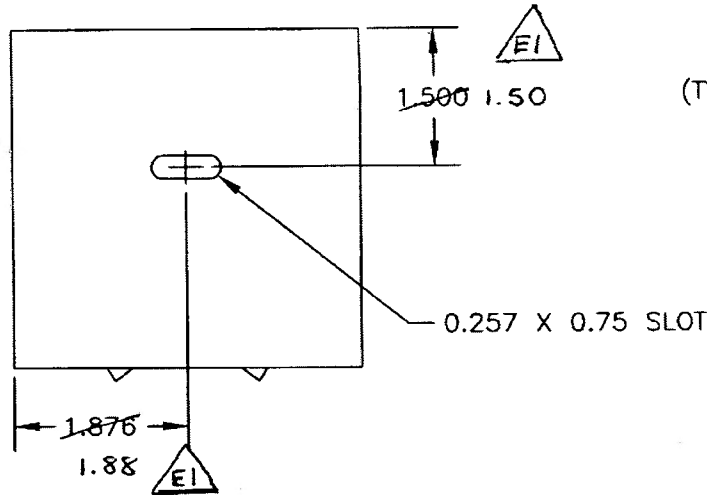


DESIGN	DRAWN BY	DART AEROSPACE LTD	REV. E
BW	CP	HAWKESBURY, ONTARIO, CANADA	
CHECKED KE	APPROVED JH	DRAWING NO. D2362	SHEET 2 OF 3
DATE 98.12.04		TITLE STEP SUPPORT BRACKET	SCALE 1:2

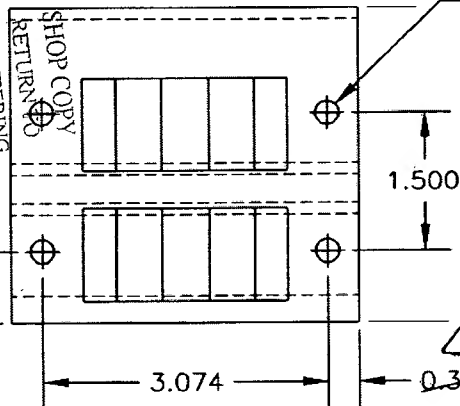
RELEASED
98.12.14 KE
UNDER REVIEW

DESIGN OK, BUT CHECK BY
DB BEFORE MANUFACTURE
OK 12/14/05

VIEW A-A



UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE



D2362-1 & D2362-5

BLACK ANTI-SKID PAINT FOR D2362-1
INSTALL D2397-5 (1) FOR D2362-5

NOTES:

MAKE FROM D2265

D2362-1: BLACK ANTI-SKID PAINT PER DART QSI 005 4.4

D2362-5: INSTALL D2397-5 RUBBER CUSHION. ALIGN RUBBER HOLE WITH SLOT
AND BOND USING CONTACT CEMENT PER MANUFACTURER'S SPECIFICATION

FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER QSI 005 4.3

BEFORE ANTI-SKID PAINT OR BEFORE INSTALLING D2397-5

TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

D2362-041 (SHOWN)

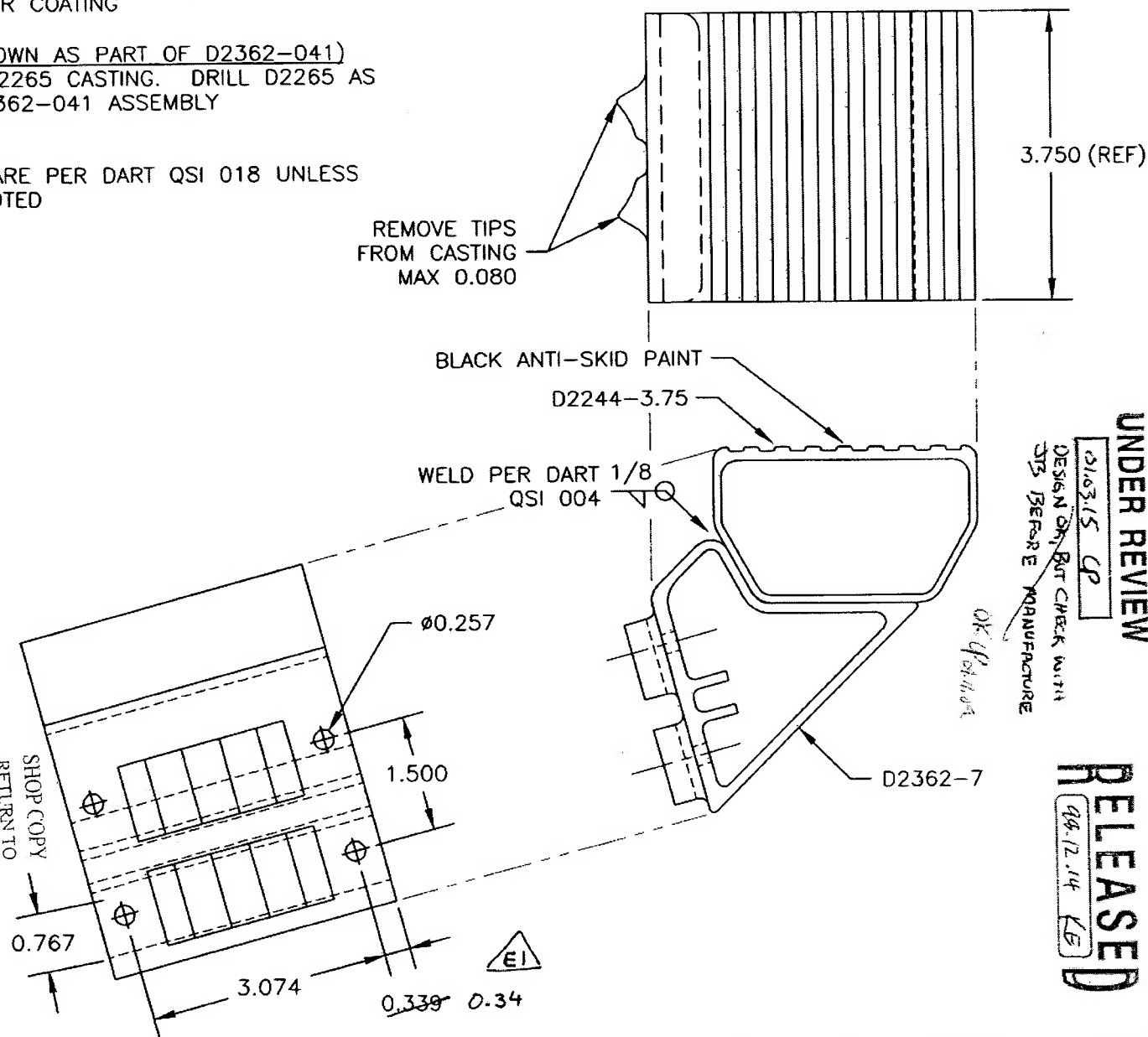
FINISH: POWDER COAT WHITE (REF. 4.3.5.1) PER
QSI 005 4.3
ANTI-SKID PIAINT PER QSI 005 4.4 AFTER
POWDER COATING

D2362-7 (SHOWN AS PART OF D2362-041)

MAKE FROM D2265 CASTING. DRILL D2265 AS
SHOWN IN D2362-041 ASSEMBLY

NOTES:

TOLERANCES ARE PER DART QSI 018 UNLESS
OTHERWISE NOTED



DESIGN	BW	DRAWN BY	CP	DART AEROSPACE LTD
CHECKED	KE	APPROVED	KE	HAWKESBURY, ONTARIO, CANADA
DATE	98.12.04	TITLE	STEP SUPPORT BRACKET	REV. E
				SHEET 3 OF 3
				SCALE 1:2

UNDER REVIEW

01.03.15 CP
DESIGN OK BUT CHECK WITH
DTS BEFORE MANUFACTURE

RELEASED
04.12.14 KE

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 35328